

Customer	:	CU-DAR001 Dart Helicopters Services	Drawing Name	:	RING
Job Number	:	32503B			
Estimate Number	:	10395			
P.O. Number	:	N/A	Part Number	:	D29685
This Issue	:	5/23/2007 S.O. No. : N/A	Drawing Number	:	D2968
Prsht Rev.	:	NC	Project Number	:	N/A
First Issue	:	N/A Type : MACHINED PARTS	Drawing Revision	:	B1
Previous Run	:	31957B	Material	:	N/A
Written By	:		Due Date	:	6/30/2007
Checked & Approved By	:	JH 07.05.24			
Comment	:	Est.C 03.04.11 Reformat; Incorporated D2968-1/-5 KJ/RF			

Qty: 30 Um: Each

Job Number:

1.0	M4130NT3000W500	4130 Tube 3"ODx.5"W
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25 02/06/18

2.0 MORI SEIKI MORI SEIKI CNC LATHE LARGE

Comment: MORI SEIKI LATHE
1-Turn Blank as per Folio FA049 and Dwg D2968
2-Deburr, no sharp edges

8/07/06/18

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

MS 07/06/19

40 QC8 SECOND CHECK

Comment: SECOND CHECK

7/07/06/20

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: W. C. L. D. - G.

Pc 7/8/21 (30)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: LL Date: 07/06/22
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 5/23/2007 3:43:20 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: RING

Job Number: 32503B

Part Number: D29685

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(30)

Comment: FINAL INSPECTION/W/O RELEASE

157186/22

Job Completion



4 07.06.22

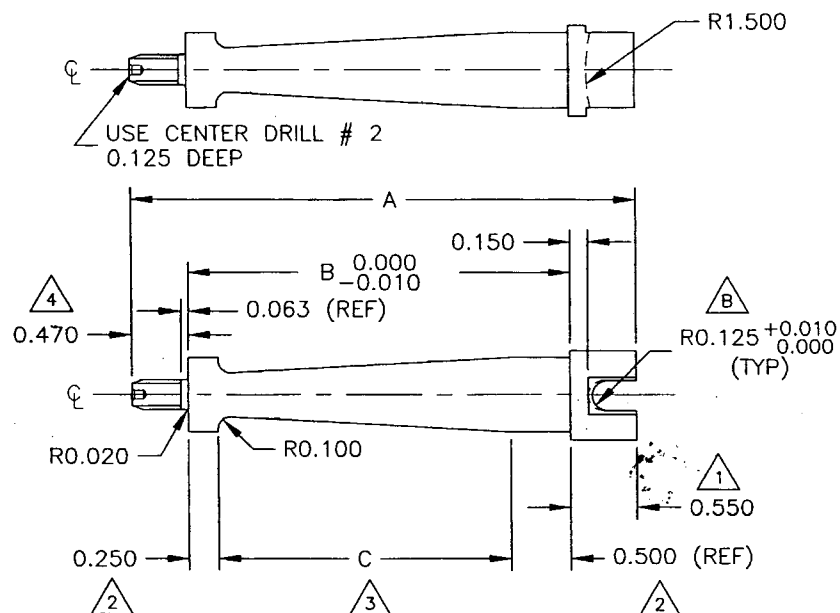
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2968-1/-3 STEM

D2968-1 AND D2968-3 STEM:

MATERIAL: AISI 4130

△ 0.750 O.D.

△ 0.625 O.D.

△ MACHINE UNIFORM TAPER FROM 0.363 O.D. TO 0.625 O.D.

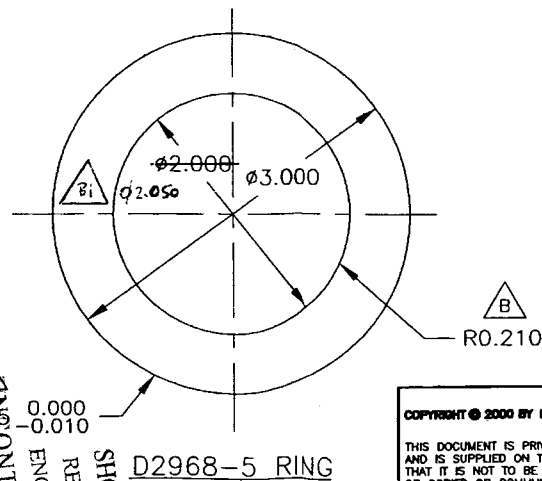
△ 1/4-28 UNF THREAD WITH 0.063 GRIP MACHINE ALL INSIDE EDGES WITH A 0.010 RADIUS UNLESS OTHERWISE INDICATED

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

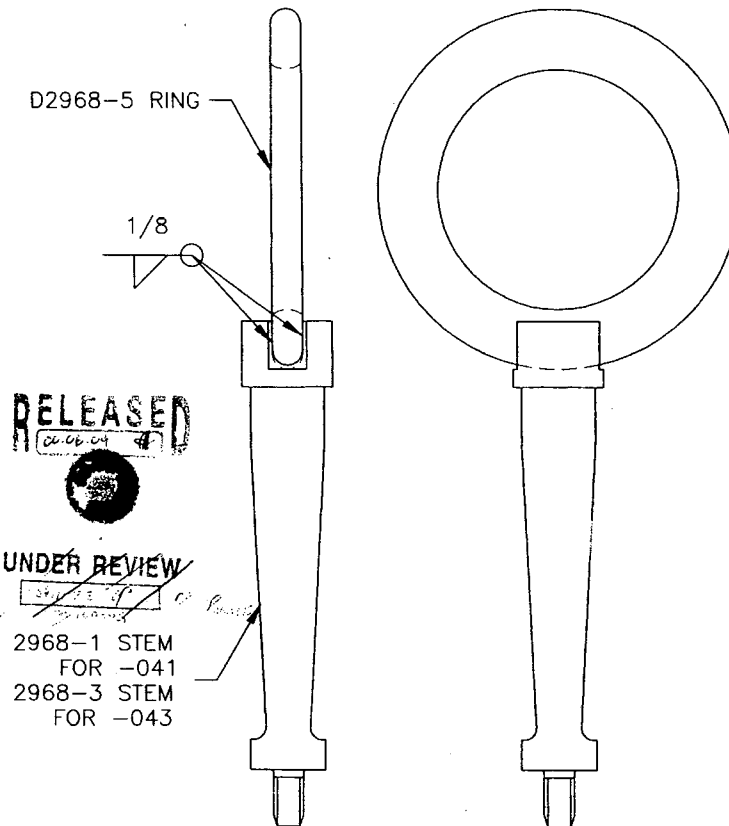
D2968-5 RING:

MATERIAL AISI 4130

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



D2968-5 RING



D2968-041 AND D2968-043 TOW RING:

WELD PER QSI 004 ON ALL EDGES BETWEEN STEM AND RING

HEAT TREAT TO MIN ULTIMATE TENSILE STRENGTH OF 125 KSI

FINISH: CAD PLATE ENTIRE ASSEMBLY PER

QQ-P-416F CLASS I TYPE II

POWDER COAT WHITE (REF 4.3.5.2) PER DART

QSI 005 4.3 (EXCEPT THREADS)

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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B	00.05.31	R0.125 AND R0.210 WERE 0.060 x 45°
A	00.03.07	NEW ISSUE
DESIGN	RF	DART AEROSPACE LTD. WINDSOR, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D2968
DATE	00.05.31	TITLE TOW RING
		REV. B SHEET 1 OF 1 SCALE 1:1

NO. 32503B
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY